

19-7746



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D3643-1

Job Sheet 193584



Part No: D3643-1

Job Qty: 8 pcs

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 5/15/19 June 6

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	8 pcs		5/15/19	0.00	0.56	Waterjet - Flow		8/17/19	JRB
110	QC 2	8 pcs		5/15/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48		JRB	8/17/19
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

<https://www.plexo.com>

Plex 4/16/19 3:22 PM Dart.lajeunesse.marie

120 QC 8	8 pcs	5/15/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	AUG 1 6 2019
				QC 8 - 52	
				QC 8 - 23	
130 Small Fab - Brake NC - B4B	8 pcs	5/15/19	0.09 0.33	Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	SEP 3 2019
				Small Fab - Brake - 3 - B4B	
140 Small Fab - 2 - B4B	8 pcs	5/15/19	0.00 0.24	Small Fab - 1 - B4B	Smf 19/9/4
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
150 QC 5	8 pcs	5/15/19	0.00 0.00	Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Handfinish - 1-1 Chemical-B4B	8 pcs	5/15/19	0.00 0.44	Handfinish - 1 - 1 - B4B	DAS 40 9-89
				Handfinish - 1 - 2 - B4B	SEP 0 4 2019
				Handfinish - 1 - 3 - B4B	SEP 0 5 2019

https://www.plexonline.com/a25018e0-a454-414a-aa0e-c8edacacd500/Plexus_Control/Report_View/Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tr... 3/4

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	7 8 pcs	5/15/19	0.00 0.00	QC 21 - SA - 21	ST046
				QC 21 - SA - 70	SEP 05 2019
				QC 21 - SA - 53	DAS
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (Small Fab) 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Chemical Conversion Coat per QSI005 4.1) 170 - (QC7-Inspect Chemical Conversion Coat) 180 - (Identify as per dwg & Stock Location:_____) 190 - (QC21- Final Inspection - Work Order Release)					21 9-89
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.040	2024-T3 .040 Sheet	1.1200 sf (.14 ea)	100-Waterjet - Flow - 1	S191572	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.040	1	171	0	
Part Specifications					
Specifications could not be found.					

Entered: HLDate: Nov 19/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7746Route update only ☐

Job: <u>193584</u>		DEPARTMENT/PROCESS				Engineering	
Part No. <u>D3643-1</u>		Cross tube				Water Jet	
		Skid-tube Machining				Supplier	
		Large Fab				Quality	
DISPOSITION		Eng. (Non-AW)					
Rework		Prod. Eng. Coord.					
Scrap		Rec/Store/Packaging					
Use-as-is							
Date: <u>SEP 04 2019</u>	Sequence #: <u>150</u>	QTY Affected: <u>10f8</u>		MRB (QS1042)			
Description Work Order Deviation		Disposition					
<u>-waterjet made a extra hole in part that's not required.</u>		<u>-scrap</u>					
Completed By <u>DAS</u>		Lead hand / Supervisor					
<u>SEP 04 2019</u>		<u>SEP 04 2019</u>					
QC / QA Coordinator		<u>19-09-04</u>					
Root Cause		FAULT CATEGORY					
Operator		Contamination		Power Loss/ Surge		Positioned Wrong	
Manufacturing Process		Misaligned/off center		Folio/Program		Outside Tolerance	
Equipment/Tooling		BOM/Route		Grain Direction		Drawing	
Handling/Preservation		Broken/Damage/Defect		Weld		Finish	
Material		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing	
Product Improvement		Drill Holes		Out of Sequence		Misread	
Process Improvement		Fit/Function		Off-set/Set-up			
Human Factors		Other/Details:					